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PATENT & TRADEMARK OFFICE

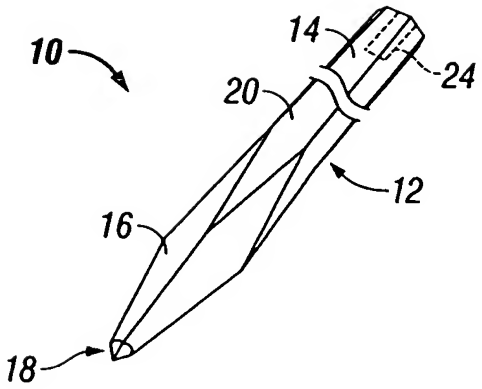

FIG. 1

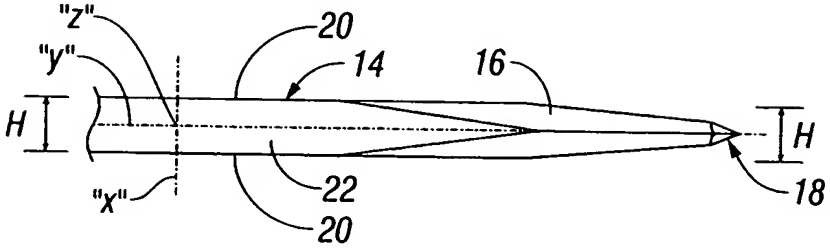

FIG. 2

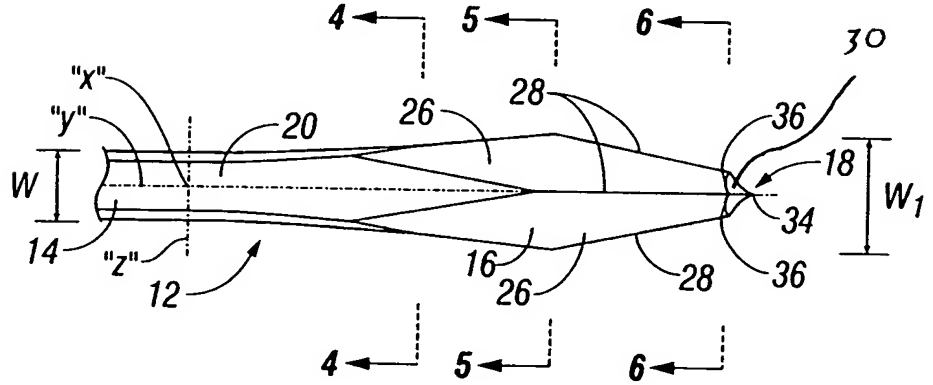

FIG. 3

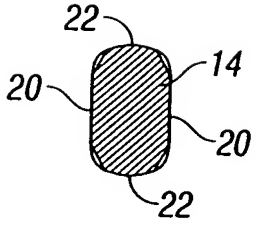

FIG. 4

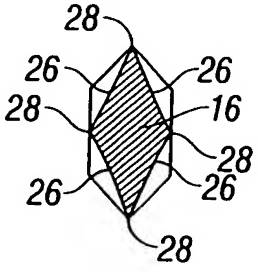

FIG. 5

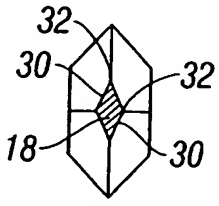

FIG. 6

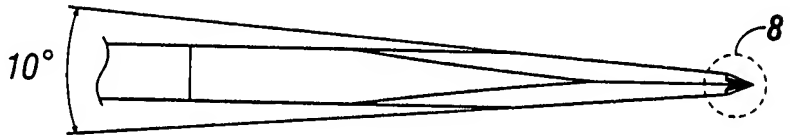

FIG. 7

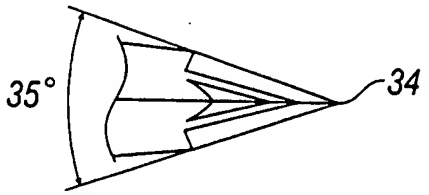

FIG. 8

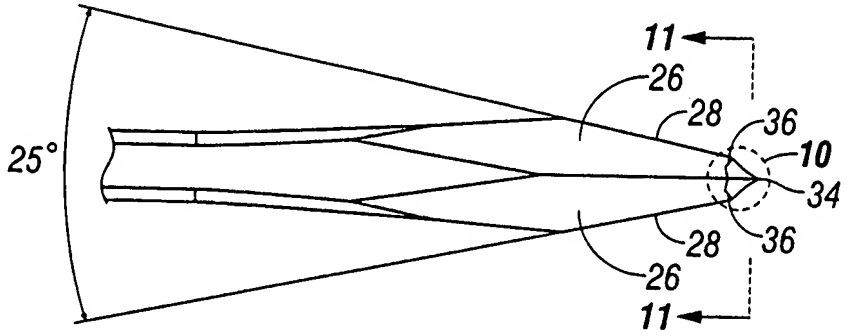

FIG. 9

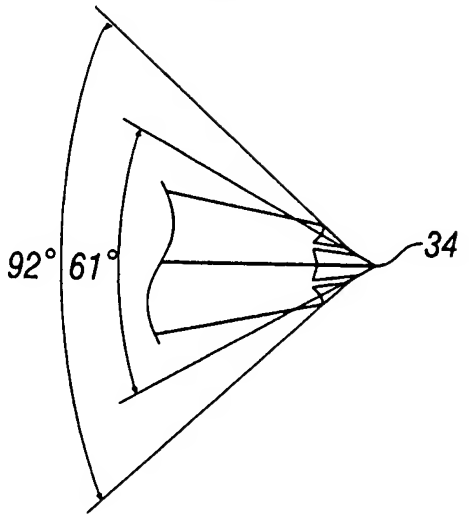

FIG. 10

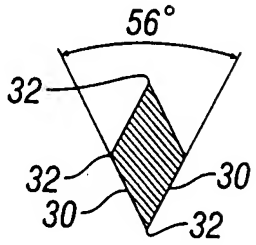

FIG. 11

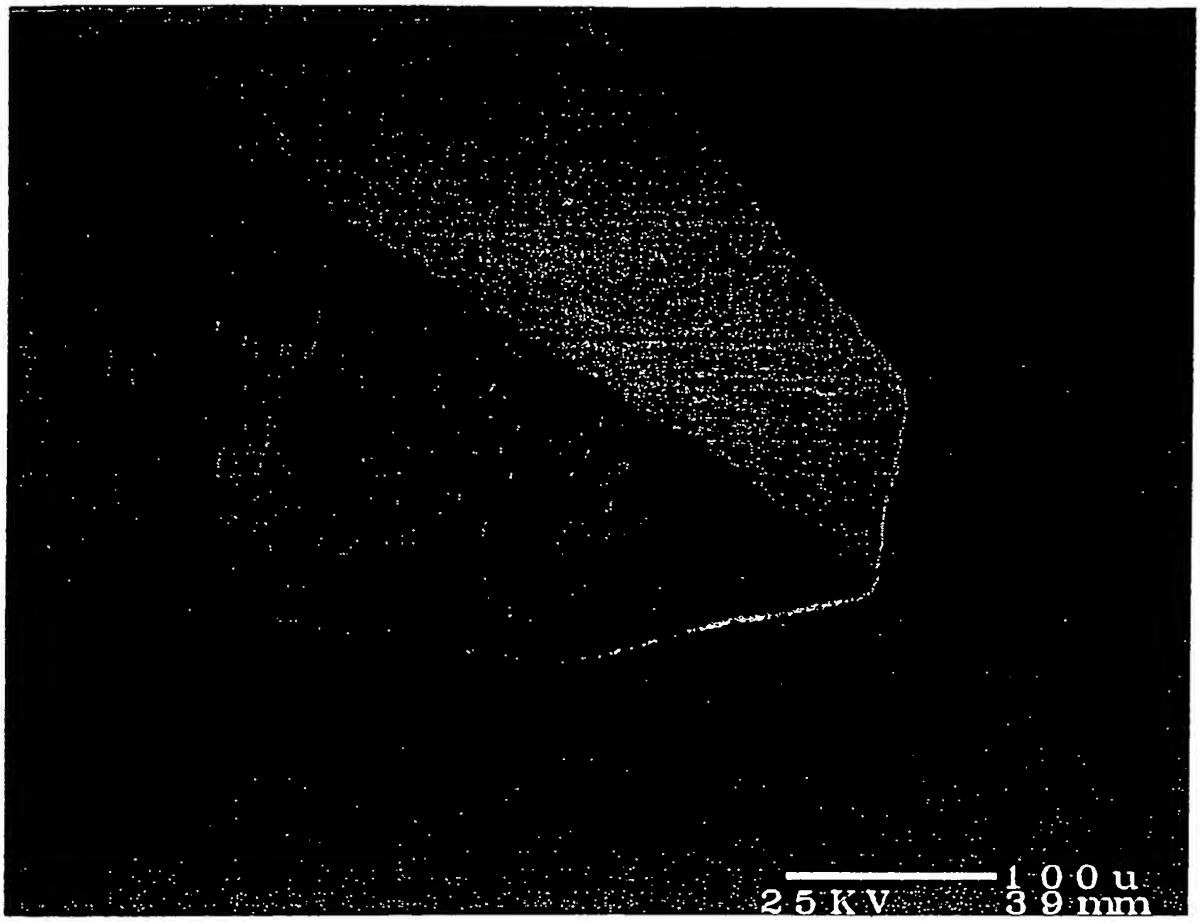

FIG. 12

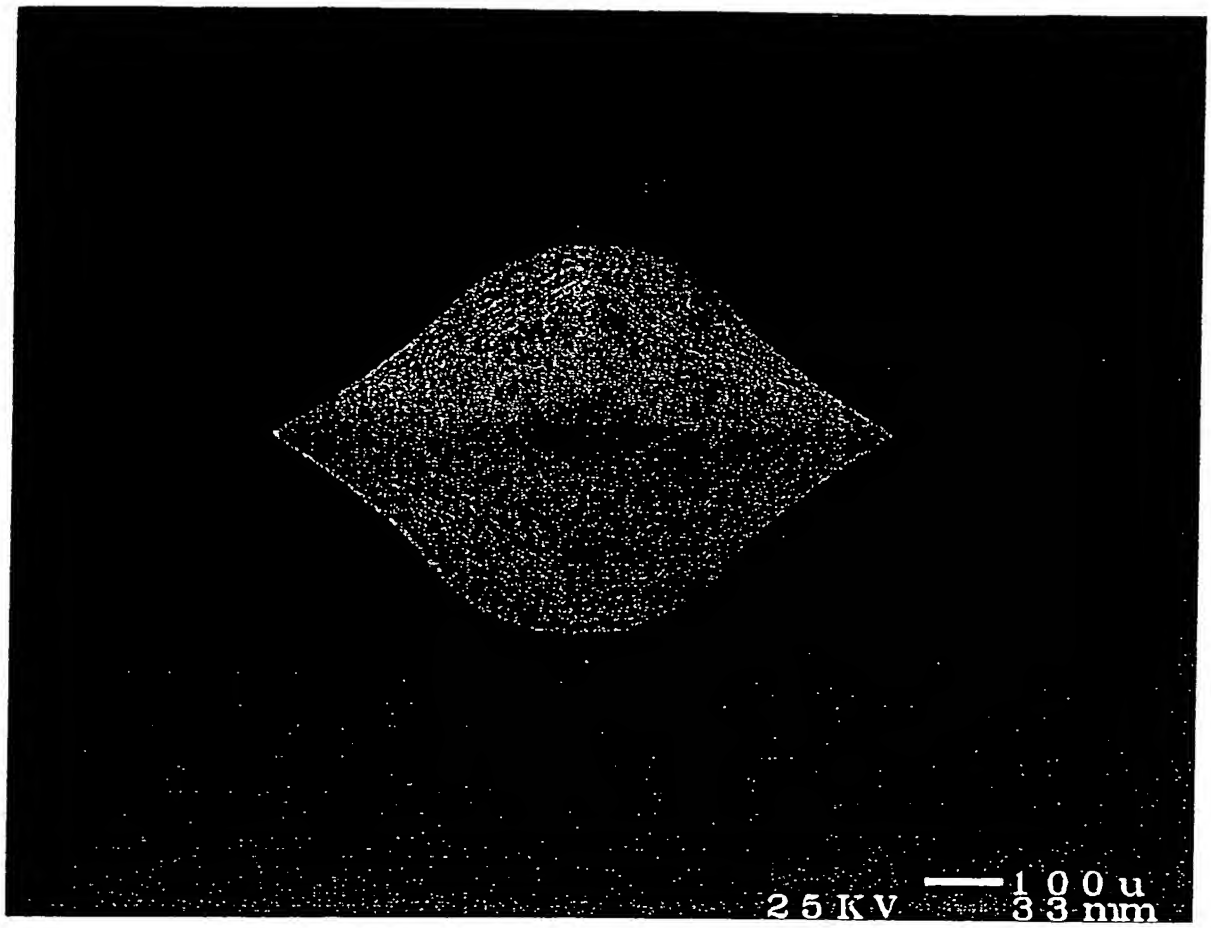

FIG. 13

Straighten and Cut to Length	~	100
Coin Point (ceat flash)	~	110
Form Body (flat press)	~	120
Form Channel Notch	~	130
Curve Needle	~	140
In Process QC	~	150
Clean Needle	~	160
Attach to Strip	~	170
Heat Treat	~	180
In Process QC	~	190
Chemical removal of Flash	~	200
Electro Polish	~	210
Clean Needle - rinse	~	220
In Process QC	~	230
Silicone Coating	~	240
Remove from Strip	~	250
Final QA	~	260
Packaging	~	270
Overhead	~	280

FIG. 14